

Date: Thursday, 2/9/2006 1:53:55 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MECHANICAL GROUND HANDLING WHEEL KIT
<b>Job Number</b> : 25781	
<b>Estimate Number</b> : 12140	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206731042
<b>This Issue</b> : 2/9/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : IIN-D206-731 pg 4,6
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 25784	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 3/15/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>KA 06.02.10</i>	
<b>Comment</b> : est rev. A 01.02.01 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
-----	--------	--------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	<i>B25909</i>

*CPL 06-08-24*

2.0	D3353041	LUG ARM WELDMENT
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3353-041	LUG ARM WELDMENT	<i>B2580Z</i>

*CPL 06-08-22*

3.0	D3354042	MIRROR ARM WELDMENT
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-042	Left Arm Weldment	<i>B25911</i>

*CPL 06-08-22*

4.0	D33561	pin
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	<i>B25912</i>

*CPL 06-08-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR) :						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25781

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3397041

wheel ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	D3397-041	Wheel ass'y

batch

325804

CPL 06-09-07

6.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	113-800	GREASE FITTING

batch

M101058

CPL 06-08-24

7.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	656-051	flat washer

batch

M17413

CPL 06-08-24

8.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	663-079	Lock washer

batch

M16362

CPL 06-08-24

9.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN5-23A	Bolt

batch

M19218

CPL 06-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:53:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25781

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	<del>M117619</del> M101369

CPL 06-08-24

11.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	SNF-34 CP21	1/8" Cotter Pin 2" long	M16301

CPL 06-08-24

12.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	M101648

CPL 06-08-24

13.0

SNF34

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	SNF-34	1/8" Cotter Pin 2" long	M16354

Slotted Nut

CPL 06-08-24

14.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	M16588

CPL 06-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 04/09/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25781

Part Number: D206731042

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 TP134 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty Part Number Description  
1 TP-134 Spring pin

batch:

M16362

CPL 06-08-22

16.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

CPL 06-09-07

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20-07-07 ①

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

19.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/15 ①

Job Completion



2 06-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PRELIMINARY ISSUE

## 4.0 PARTS LIST

QTY -011	QTY -041	QTY -042	Part Number	Description
X			D206-731-011	MECHANICAL GROUND HANDLING WHEEL KIT
1	X		D206-731-041	MECHANICAL GROUND HANDLING WHEEL (LH)
1		X	D206-731-042	MECHANICAL GROUND HANDLING WHEEL (RH)
	1	1	D3335-5	* SPRING
		1	D3353-041	* LUG ARM WELDMENT
	1		D3353-042	* LUG ARM WELDMENT
	1		D3354-041	* LEFT ARM WELDMENT
		1	D3354-042	* MIRROR ARM WELDMENT
1			D3355-041	* HANDLE ASSEMBLY
	1	1	D3356-1	* PIN
	2	2	D3397-041	* WHEEL ASSEMBLY
1			D3381-1	** LABEL
	1	1	113-800	* GREASE FITTING
	2	2	656-051	* FLAT WASHER
	1	1	663-079	* LOCK WASHER
	1	1	AN5-23A	* BOLT
	1	1	AN960JD516	* WASHER
	2	2	CP-21	* COTTER PIN
	1	1	MS21042L5	* NUT
	2	2	SNF-34	* SLOTTED NUT
	1	1	TP-2	* SLOTTED SPRING TENSION PIN
	1	1	TP-134	* SLOTTED SPRING TENSION PIN

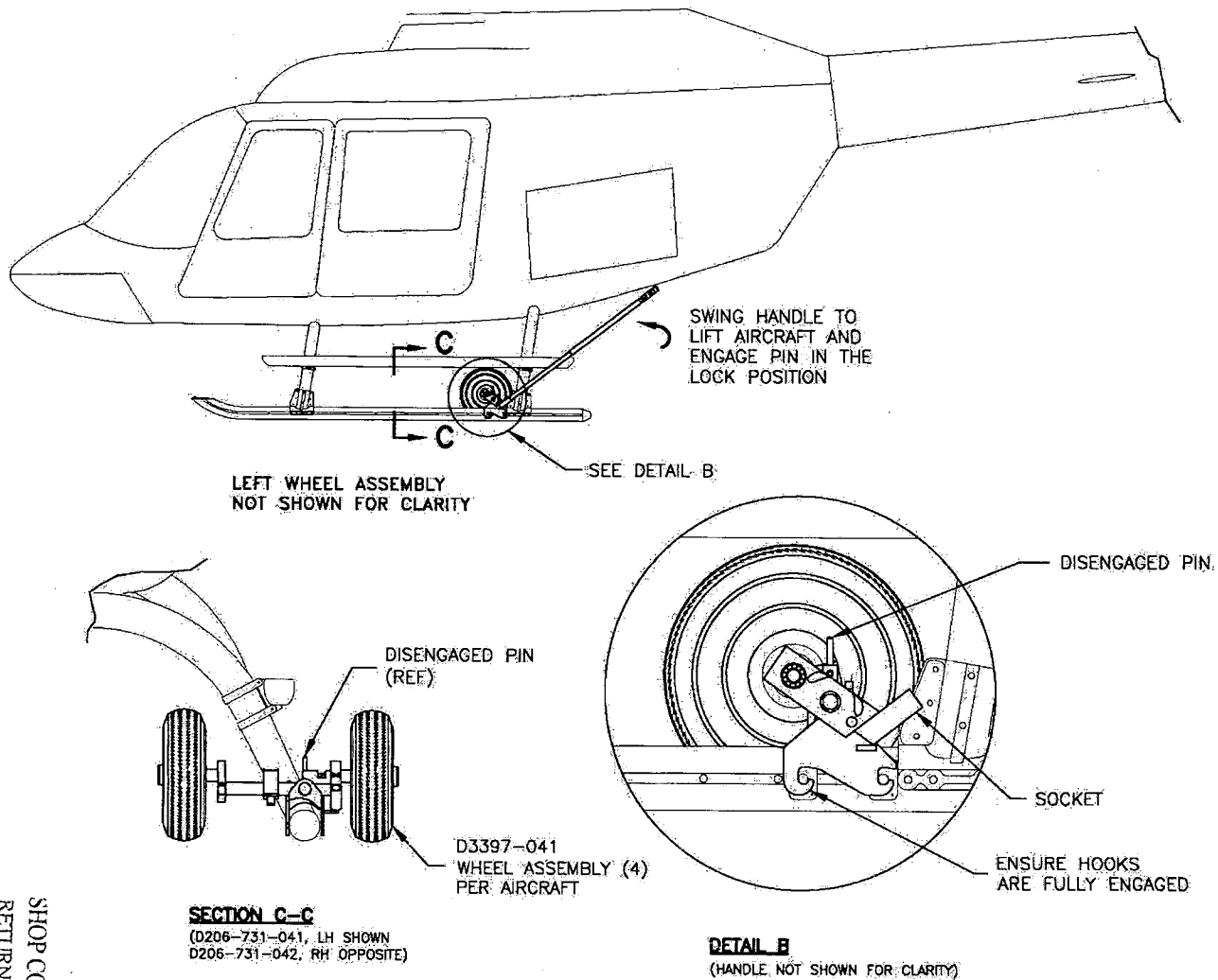
\* shown for reference only, part is included in D206-731-041/ -042 assemblies above

\*\* shown for reference only, part is included in D3355-041 assembly above

D3354-043 ?

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PRELIMINARY ISSUE



**Figure 2 – D206-731-041 Mechanical Ground Handling Wheel Installation  
(Left Side Shown, Right Side Opposite)**

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